

Date  
UserThursday, 11/9/2006 4:37:12 PM  
Kim Johnston

## Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 29388  
**Estimate Number** : 10311  
**P.O. Number** : N/A  
**This Issue** : 11/9/2006 **S.O. No.** : N/A  
**Prsht Rev.** : NC  
**First Issue** : N/A **Type** : LANDING GEAR  
**Previous Run** : 28932  
**Written By** : HA 061110  
**Checked & Approved By** : HA 061110  
**Comment** : Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF

**Drawing Name** : 206 EXTRUSION BENDING  
**Part Number** : D2620  
**Drawing Number** : D2620 REV B  
**Project Number** : N/A  
**Drawing Revision** : B  
**Material** : N/A  
**Due Date** : 11/24/2006

**Qty:** 40 **Um:** 20 **Each**

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26001160 Extrusion Round 3" 206



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	<del>29388</del> 24508

DD  
 7-112  
 (41)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



**Comment:** LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

GR/D

ELA  
 07/11/12

(41)

3.0 QC5 INSPECT WORK TO CURRENT STEP



**Comment:** INSPECT WORK TO CURRENT STEP

BE 07/1/15 (41)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: LC

BE 07/1/15

(41)

5.0 QC21 FINAL INSPECTION/W/O RELEASE



**Comment:** FINAL INSPECTION/W/O RELEASE

(41)  
 07/10/11

Job Completion



CL07101119

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/19

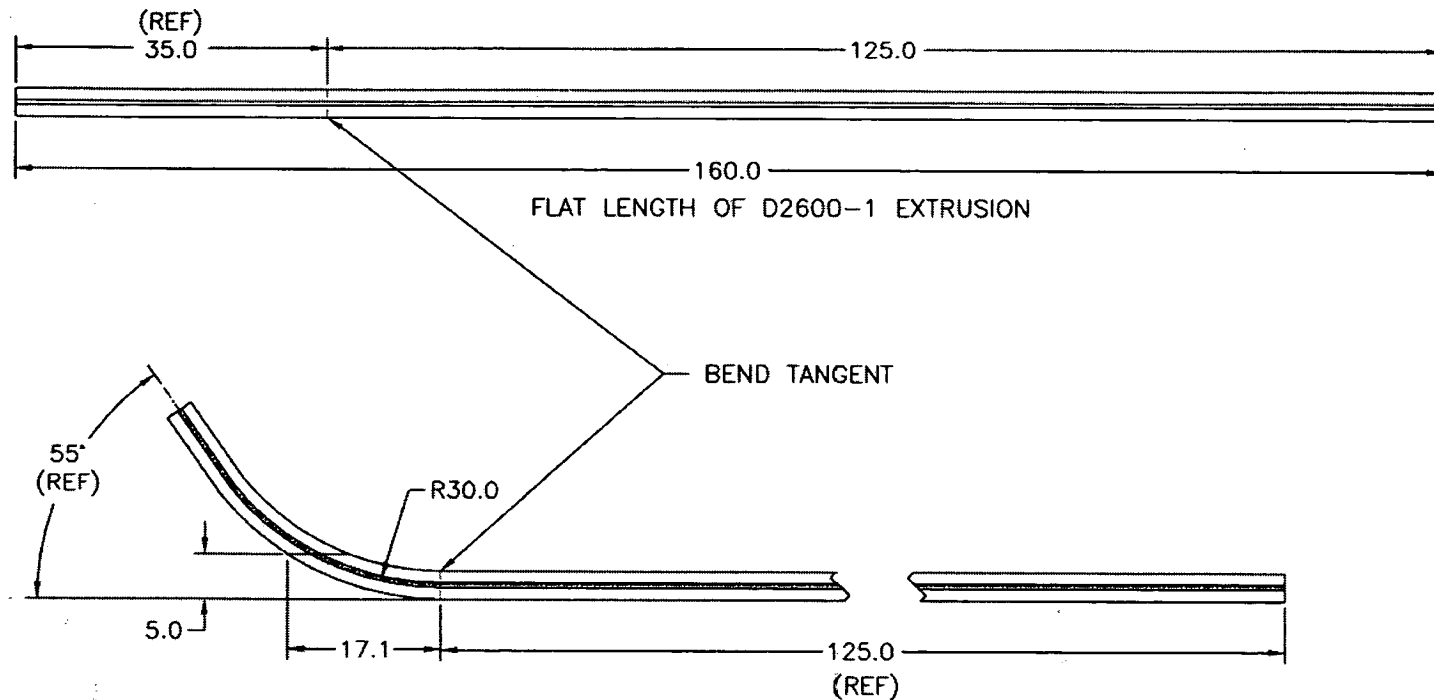
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# SPECIFICATION CONTROL DRAWING

## 206 SKIDTUBE BENDING



### DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
  2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
  3. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
  4. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND.
  5. TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
  6. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND.
  7. TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
- NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED  
44-04-15 DS

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, VA
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE 1:20

